DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-015526
Date Inspected: 02-Jul-2010

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island

OSM Arrival Time: 700
OSM Departure Time: 1900
Location: Shanghai, China

CWI Name:	ZPMC and ABF	**CWI Present:**	☑ Yes ☐ No
Inspected CWI report:	☑ Yes ☐ No ☐ N/A	**Rod Oven in Use:**	☑ Yes ☐ No ☐ N/A
Electrode to specification:	☑ Yes ☐ No ☐ N/A	**Weld Procedures Followed:**	☑ Yes ☐ No ☐ N/A
Qualified Welders:	☑ Yes ☐ No ☐ N/A	**Verified Joint Fit-up:**	☑ Yes ☐ No ☐ N/A
Approved Drawings:	☑ Yes ☐ No ☐ N/A	**Approved WPS:**	☑ Yes ☐ No ☐ N/A
		Delayed / Cancelled:	☐ Yes ☑ No ☐ N/A

Bridge No: 34-0006
Component: OBG 13 section

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #6

Caltrans QA Inspector observed two ZPMC welders in process SMAW CJP process on west jacket frame (WJF) leg. The CJP weld is designed single bevel with back bar welded in flat position. The WJF and weld ID is WJF-0-182~184 and WJF-0-185~188. The SMAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

Caltrans QA inspector observed a fit up groups performed fit up and SMAW tack weld process on cover plate of WJF box. The weld is designed T-joint is attached to WJF box with seal weld. The WJF box ID is WJF-0-456.A numerous temporary tack welds have been welded attach between T joint after adjusted and secured by hand jack. The fit up SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Bay#7

Caltrans QA Inspector observed three welding operators in process of semi-automatic FCAW on stiffeners. The stiffener weld is designed PJP with T-joint weld and located on the bottom plate. The bottom plate and stiffener weld ID is SP3060A/SP3060-001-013~048. All of PJP joint regions have been pre-heating to specific desired temperature prior welding. The semi-automatic FCAW process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA inspector observed a fit up groups performed fit up and SMAW tack weld process on T-joint fillet weld. The T-joint is attached to stiffeners and edge plate with 22mm wall thick. The edge plate number is EP3014A. A numerous temporary tack welds have been welded attach between side plate and stiffeners after adjusted and secured by hand jack. The fit up SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Bay# 8

Caltrans QA inspector observed a ZPMC welder performed FCAW PJP process on OBG flatness retrofit plate type A3. The weld is designed T-joint plate to plate with PJP weld. Total four retrofit plate type A3 have been completed the welding. The plate ID is A3-15/16/17/18. The region of the weld joint has been pre-heating to specific desired temperature prior FCAW welding. The FCAW process were monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA Inspector observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

in process of semi-automatic FCAW on stiffeners for bottom plate


welding in process on the retrofit plate type A-3


tack welds process on cover plate of WJF box.

Summary of Conversations:

As notes within report above

Comments

WELDING INSPECTION REPORT

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784 , who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer